

Work Order ID 130255

130255

Page 1

Monday, March 02, 2015 10:37:40 AM

Item ID: D2965 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 3/2/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/2/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference: SPRAY PAINT MATTE BLACK

Approvals: Process Plan: MUF Date: 15-2-02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2965	Rev B								

220 Spray Painting per QSI005 4.2 0.00
220
 SprayPaint Memo 0.00
 Spray Painting PULL FROM STOCK D2965 X 2 B127852
 SCUFF LIGHTLY

PRIME AS PER DWG (REF. 4.2.1.3.2)
 A/R PRIMER BATCH: 130992
 PAINT MATTE BLACK AS PER DWG (REF. QSI 005 4.3)
 A/R PAINT BATCH: 130925

230 QC14- Inspect Spray Paint 0.00
230
 QC Memo 0.00
 Quality Control

2 CR 15-03-06
Pa d JH 15/03/15 15
PTO 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-03-11	220	②	Paint is too glossy Desoto primer used instead of Tempo		Scuff & Re Apply Topcoat B # 131561	DAS 41 9-89 15-3-18	15/03/19 X2 DAS VS 9-89	
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DQA:

Date: 18/03/25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/03/25

Work Order update only ☐

Work Order: 130255	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. D2965	Rework ☒	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. 15-4711	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/3/19	220	2	Desoto primer was used instead of tempo	DAS 12 9-89 15/3/19	Primer is acceptable. Desoto is superior to standard primer.	DAS 12 9-89 15/3/19	15/03/19 X1 68-6 15 DAS	DAS 9 9-89 15-3-19.
Doc/Data				R.C. operator not following QSI					
Equip/Tooling				Paint is too glossy.					
Handling/Pre				no paint sample to compare different shades of paint		Scuff the & re apply top coat B# 131561			
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General					
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced			
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up			
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure			
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld			
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled			
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong				
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other			
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread					
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set					
☐ Turning Sequence	☒ Finish	☐ Out of Calibration					
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence					

Work Order ID 130255***130255***

Monday, March 02, 2015 10:37:40 AM

Item ID: D2965

Accept

N900040100

Setup Start *

Revision ID:

Stop *

Item Name: Cap

Start Date: 3/2/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/2/2015 Req'd Qty: 2.00

2

Customer:

Reference: SPRAY PAINT MATTE BLACK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject
Qty Qty Number

240

Identify as per dwg & Stock Location: P-001

0.00

240

Packaging

Memo

0.00

Packaging

x2 of 15103114

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

MLJ 1503-23

YMF
153-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Monday, March 02, 2015 10:37:32 AM

Work Order ID: 130255

130255

Parent Item: D2965

D2965

Parent Item Name: Cap

Start Date: 3/2/2015

Required Date: 3/2/2015

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP: A00.05.31New Issue EC

IPP Rev:Added Turning as per Rev B 06-12-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2965

Manufactured

No

Each

112.0000

2

D2965

Cap

Location

Loc Qty

Loc Code

FP001

112

127852

103

99551

9

JMF 15-3-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Equip/Tooling									
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